

Date: Tuesday, 17/02/2009 10:18:10 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE BLOCK
<b>Job Number</b>	: 45810		
<b>Estimate Number</b>	: 10324		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D1049
<b>This Issue</b>	: 17/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D1049 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39919	<b>Drawing Revision</b>	: A
	<b>Type</b>	<b>Material</b>	:
	: MACHINED PARTS	<b>Due Date</b>	: 03/03/2009
<b>Written By</b>	:	<b>Qty:</b>	20
<b>Checked &amp; Approved By</b>	: <u>JUD 09-02-17</u>	<b>Um:</b>	Each
<b>Comment</b>	: Est RevC 02.04.10 Re-format NG		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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**Comment:** Qty.: 0.1749 f(s)/Unit Total: 3.4986 f(s)

Material: 6061-T6 bar .750 wide x .250 thick.

Batch: M110829 .375X.750 X 4 parts

30.375 x .750

M18237 X 16 parts

88 09/02/19

2.0	SHEAR	SHEAR
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**Comment:** SHEAR

Cut Blanks: 2.000" long

88 09/02/19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

9th 09/02/25

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

9th 09/02/25

(20)

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SA 09/02/25

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:10 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 45810

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-26

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

(20)

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL 09/03/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-01

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2

9/3/4

(20K)

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05

Job Completion



MF  
09-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

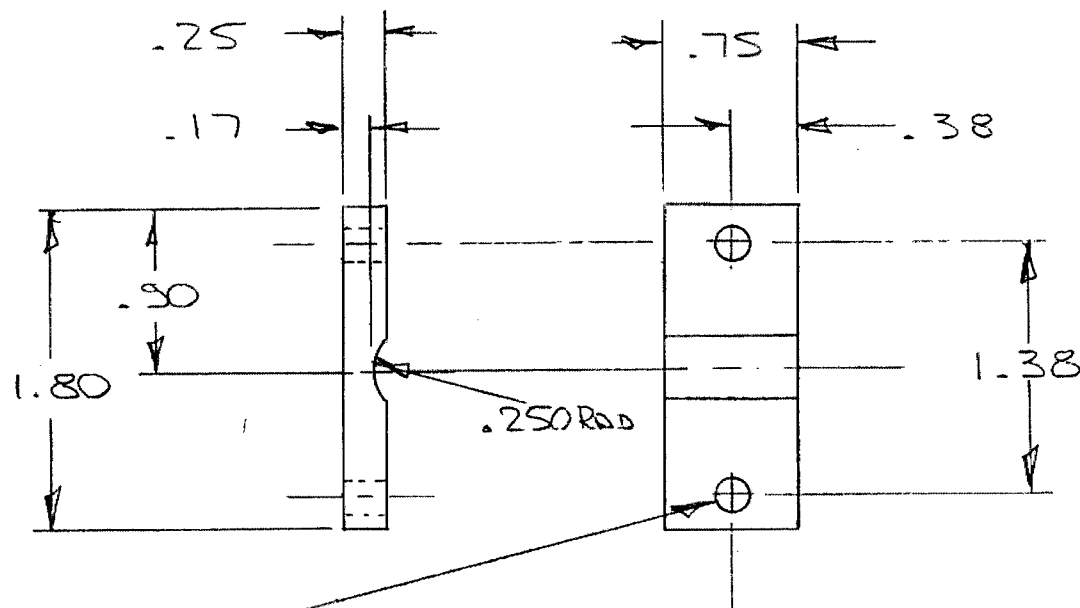
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED-  
9710702 Bw



.203 DIA.  
TYP

MATERIAL: 5052-H32

FINISH: POWDER COAT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
#5810

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMM'D OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DRAWN			BASIC CODE		CONTRACT NO.		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			DASH NO. 10-HEAD NEAR SIDE 10-HEAD FAR SIDE		DATE 1992				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .001 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. — 8 — 7242 5. HOLES PER AHD 10347 1. TOLERANCES — .001 & .030 2. ANGLES 1/2 IN. 3. PARALLELISM 1/2 .0015 4. ECCENTRICITY .001 MAX 5. SYMMETRY ABOUT ALL M.C. CENTRE LINES .001		BASIC CODES 82-MS20470AD 88-MS20476AD		DRAWN DESIGNED CHECKED CLIENT		TITLE SADDLE CODE D1049 SCALE 1:1 SHT 1 OF 1		
REPORT ALL DISCREPANCIES — DO NOT SCALE									